

Date: Monday, 02/02/2009 11:49:45 AM  
 User: Julie Dawson

## Process Sheet

<b>Customer</b> : CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> : CLAMP
<b>Job Number</b> : 45382	
<b>Estimate Number</b> : 10584	
<b>P.O. Number</b> :	<b>Part Number</b> : D1048
<b>This Issue</b> : 02/02/2009 <b>S.O. No.</b> :	<b>Drawing Number</b> : D1048 REV A
<b>Prsht Rev.</b> : NC	<b>Project Number</b> : N/A
<b>First Issue</b> : / / <b>Type</b> : SMALL /MED FAB	<b>Drawing Revision</b> : A
<b>Previous Run</b> : 44359	<b>Material</b> :
<b>Written By</b> :	<b>Due Date</b> : 28/02/2009 <b>Qty:</b> 50 <b>Um:</b> Each
<b>Checked &amp; Approved By</b> : <u>JLD 09.02.02</u>	
<b>Comment</b> : Est: B 02.02.22 Re-format NG Est Rev:C Now on Waterjet 06-12-06 JLM	

## Additional Product

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
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1.0	M304S16GA	304/316 Sheet .063
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**Comment:** Qty.: 0.0189 sf(s)/Unit Total: 0.9450 sf(s)

304/316 .063 Sheet

Batch: 110551ml 09 03 0550

2.0	WATER JET	FLOW WATER JET
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**Comment:** FLOW WATER JET

1-Cut as per Dwg D1048

Dwg Rev: AProg Rev: A

2-Deburr if necessary

ml 09 03 0550

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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**Comment:** INSPECT PARTS AS THEY COME OFF MACHINEml 09 03 0550

4.0	QC8	SECOND CHECK
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**Comment:** SECOND CHECK8 02/03/05center  
50

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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**Comment:** SMALL & MEDIUM FAB RESOURCE 1

1-Deburr if required. Break all sharp corners .010 / .020 as per dwg.

u / 7

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: CLAMP

Job Number: 45382

Part Number: D1048

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

BRAKE NC

NC BRAKE



Comment: NC BRAKE

1-Form as per dwg D2010 using DT8053

FF 09/03/06

(50)

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

5 09/03/06 carter (50)

8.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3

START TIME:

10:55

OVEN TEMPERATURE:

320°

FINISH TIME:

11:25

UMP/BR

09/03/10

(150)

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

09-03-10

(50)

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 2

9/3/10

SLP

50x

11.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/03/11

Job Completion



h 09-03-11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



97/09/02 B.

## 1) MATERIAL

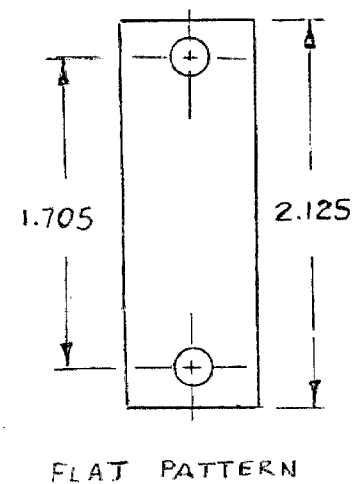
## STAINLESS STEEL

T304#ZB .062 THICK

2) FINISH: POWDER COAT BLACK SANDTEX (REF. 4.3.5.7)


PER DART QSI 005 4.3

3) BREAK ALL SHARP EDGES 0.010 TO 0.020



FLAT PATTERN

GA COPY ISSUED

01-2-05 ADD FLAT PATTERN	A	REVISION	THIS DRAWING IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT THE PERMISSION OF DART AERO.	RIVET CODE SHALL BE PER NAS 523		PART NO.	ITEM	DESCRIPTION	MATERIAL	SPEC./VENDOR		
	RF	DRAWN		BASIC CODE	DL DASH NO. W/HEAD NEAR SIDE F=HEAD FAR SIDE	CONTRACT NO.		<div> DART AERO ACCESSORIES INC VANCOUVER CANADA</div>				
	<del>APPROVED</del>			D=DOUBLE DIGIT=NO OF SHEETS C=COUNTERSINK	LENGTH DASH NO. W=SPOTWELD	DRAWN BRADLEY	DATE 5/17					
	DESCRIPTION	REQUIREMENTS — UNLESS OTHERWISE SPECIFIED			DESIGN BRADLEY		TITLE CLAMP					
	OF	GENERAL			BASIC CODES							
	CHANGE	LIMITS			B=MS20470AD BB=MS20476AD		STRESS		CODE	DWG NO. D 1048	REV A	
	1. DIMENSIONS IN INCHES			1. TOLERANCES — JXX ± .030			REPORT ALL DISCREPANCIES — DO NOT SCALE					
	2. SURFACE ROUGHNESS 125 μ			JXX ± .010								
	3. REMOVE SHARP EDGES .015 MAX			2. ANGLES 2 W								
	4. THREADS PER IN. S - 2742			3. PARALLELISM ± .0025								
5. HOLES PER IN. 10387			4. ECCENTRICITY .005 MAX.			CHECKED		SCALE	1 : 1	SHT	OF	
			5. SYMMETRY ABOUT ALL MFC CENTRE LINES .005			CLIENT						

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries